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D2563

Job Sheet 184919



Part No: D2563

Job Qty: 2 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 10/30/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/30/18	10/30/18	0.00	0.00	Start Up Large Fab-2		CC
100	Large Fab	2 pcs	10/30/18	10/30/18	0.00	2.94	Large Fab 2		CG
110	QC	2 pcs	10/30/18	10/30/18	0.00	0.00	QC9		SA
120	QC	2 pcs	10/30/18	10/30/18	0.00	0.00	QC5		SA
130	HandFinish	2 pcs	10/30/18	10/30/18	0.00	0.54	HandFinish1		DR 18/10/23
140	QC	2 pcs	10/30/18	10/30/18	0.00	0.00	QC7		CPL
150	Large Fab	2 pcs	10/30/18	10/30/18	0.00	2.94	Large Fab 2		EF
160	QC	2 pcs	10/30/18	10/30/18	0.00	0.00	QC10		DS
170	QC	2 pcs	10/30/18	10/30/18	0.00	0.00	QC5		DS
175	HandFinish	2 pcs	10/30/18	10/30/18	0.00	0.54	HandFinish2		DR 18/10/25
180	Powdercoat	2 pcs	10/30/18	10/30/18	0.00	0.33	Powdercoat1		BL / BEB 18-10-26
190	HandFinish	2 pcs	10/30/18	10/30/18	0.00	0.54	HandFinish3		BEB 18-10-29 AS
200	QC	2 pcs	10/30/18	10/30/18	0.00	0.00	QC3		NOV 01 2018 68
210	Packaging	2 pcs	10/30/18	10/30/18	0.00	0.00	Packaging3		NOV 06 2018 9-89
220	QC21-SA	2 Ea	10/30/18	10/30/18	0.00	0.00	QC21		NOV 06 2018

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & Descriptions: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME:

M138951 START: 9:10 TEMP: 320° FINISH: 9:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	B164522-75-1
D2561	Lug	4 Ea (2 ea)	90-Start up Operation	5077405
D2564	Mounting Angle	4 Ea (2 ea)	90-Start up Operation	5084940
D2673-34	End Plate	2 Ea (1 ea)	90-Start up Operation	5063804
D2673-34	End Plate	2 Ea (1 ea)	150-Large Fab	5063804

Wing Walk 5098120

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	26	0
	D2561	4	8	0
	D2564	4	6	0
	D2673-34	2	39	0
150-Large Fab	D2673-34	2	39	0
Part Specifications				
Specifications could not be found.				

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Container No: S120202



Part: D2563

Job No: 184919

Serial No/Batch: S120202

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/22/18